

**SUBSTITUTE ABSTRACT**

**Abstract of the Disclosure**

A coding method with dynamic positioning is used in a die pick-up process. The steps include picking up one of the dies and examining the dies for classifying the grade of the dies for deposit in their exclusive bin. In the meantime, the method classifies the exclusive bin for each grade of die during the process, and continues to perform the die pick-up process until all the dies are picked-up.